



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D2666-2

Job Sheet 190712



Part No: D2666-2

Job Qty: 4 pcs

Part Name: Saddle, RH, Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/13/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: Stock *Handwritten: SOW*

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	3/18/19		0.00	0.00	HAAS - 1		19/3/11 <i>Handwritten: Uff</i>
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	3/18/19		0.00	0.62	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	3/18/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S157834



Part: D2666-2

Job No: 190712

Serial No/Batch: S157834

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/28/19

				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 8 - 12	M/L 19/03/04
				QC 8 - 14	
QC 8 - 17					
QC 8 - 20					
QC 8 - 25					
QC 8 - 3					
QC 8 - 32					
QC 8 - 33					
QC 8 - 35					
QC 8 - 39					
QC 8 - 4					
QC 8 - 44					
QC 8 - 45					
QC 8 - 49					
QC 8 - 58					
QC 8 - 8					
QC 8 - 9					
QC 8 - 68					
QC 8 - 67					
QC 8 - 47					
140 Handfinish - 1-1 Chemical-B4B	4 pcs	3/18/19	0.00 0.00	Handfinish - 1 - 1 - B4B	D.R 19/03/04
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White Gl(A)-B4B	4 pcs	3/18/19	0.00 0.14	Powdercoat - 1 - B4B	BEB 19-03-04
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	4 pcs	3/18/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				Plex 2/13/19 2:39 PM Dart.lajeunesse.mari	

					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	DAS 68 MAR 04 2019
					QC 3 - 9	9-89
170	Packaging 3-1 - Stock - B4B	4 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	5740190 MAR 04 2019
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
180	QC 21 - SA	4 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	DAS 21 MAR 04 2019
					QC 21 - SA - 53	9-89
Part Op 100 - HAAS CNC Vertical Machine - Program batch number. 1-Inspect part number and batch number are programmed Descriptions: correctly. 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: 11:40 TEMP: 320° FINISH: 12:10						

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160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 pcs (1 ea)	100-HAAS 4 Axis	5067879x4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	4	49	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD				Work Order: 190712	
Description: 206 Saddle, Inboard, Right side				Part Number: D2666-2	
Inspection Dwg: D2666 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.120	0.121	0.121	0.121	
B	0.100	0.140		0.135	0.121	0.121	0.121	
C	2.470	2.510	/	2.500	2.500	2.500	2.500	
D	0.100	0.180	/	0.130	0.130	0.130	0.130	
E	0.210	0.230		0.228	0.217	0.220	0.218	
F	1.313	1.343	/	1.330	1.322	1.322	1.322	
G	0.240	0.260		0.258	0.251	0.251	0.251	
H	0.615	0.685	/	0.640	0.640	0.640	0.640	
I	1.125	1.145	/	1.135	1.135	1.135	1.135	
J	0.990	1.010	/	1.000	1.000	1.000	1.000	
K	0.235	0.240		0.237	0.237	0.237	0.237	
L	0.510	0.515	/	0.511	0.511	0.511	0.511	
M	0.100	0.120	/	0.110	0.110	0.110	0.110	
N	1.565	1.585	/	1.575	1.575	1.575	1.575	
O	5.990	6.010	/	6.003	6.000	6.001	6.002	
P	1.245	1.255	/	1.250	1.250	1.250	1.250	
Q	2.495	2.505	/	2.500	2.500	2.500	2.500	
R	0.490	0.510		0.501	0.500	0.500	0.498	
S	0.312	0.318	/	0.313	0.313	0.313	0.313	
T	2.495	2.505	/	2.500	2.500	2.500	2.500	
U	1.357	1.367	/	1.362	1.362	1.362	1.362	
V	0.315	0.322	/	0.316	0.316	0.316	0.316	
W	0.540	0.560		0.550	0.550	0.551	0.552	
X	1.674	1.684	/	1.679	1.679	1.679	1.679	
Y	0.256	0.262	/	0.257	0.257	0.257	0.257	
Z	0.178	0.198	/	0.188	0.188	0.188	0.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: BAUHA	Date: 19/3/11
Audited by: [Signature]	Date: 19/03/04
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension S and Y revised	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			